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RBT400284-139
Job Sheet 196569



Part No: RBT400284-139

Job Qty: 4 pcs

Part Name: Bull's Eye Level



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/14/19

Job Tracking No:

Due Date: 8/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 16917

Note: DWG RBT400284 Rev 1A IPP Rev. A 19.06.14 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S197251



Part: RBT400284-139

Job No: 196569

Serial No/Batch: S197251

Revision: 1A

Inspector:

Exp Date:

Instructions:

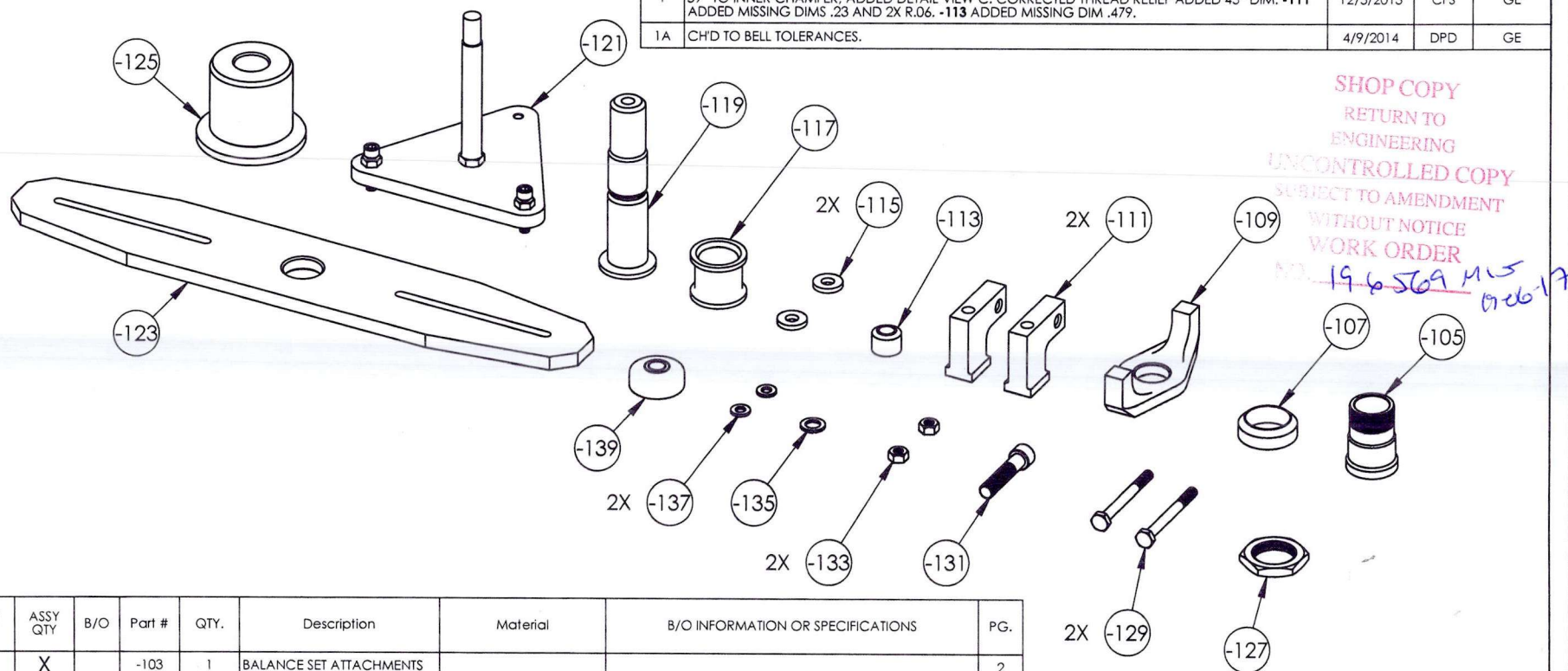
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Date: 07/11/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	Small Fab - 1	4 pcs	8/23/19	8/23/19	0.00	0.20	Small Fab - 1		
							Small Fab - 2		MCL
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	8/23/19	8/23/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	4 pcs	8/23/19	8/23/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	4 pcs	8/23/19	8/23/19	0.00	0.00	QC 21 - FG - 21		
							QC 21 - FG - 70		
							QC 21 - SA - 53		
Part Op Descriptions: 100 - Pick bag and tag. Identify as RBT400284-139.									
Job BOM									
Part / Item	Component Name	Quantity	Operation	Container					
2147A11	Circular Level Vial, Plastic, 1-3/8" Base Diameter	4 (1 ea)	100-Small Fab - 1	5196500					
Job Allocations									
Operation	Component Part	Required	Inventory	Allocated					
100-Small Fab - 1	2147A11	4	0	0					
Part Specifications									
Specifications could not be found.									

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	UPDATED SHEET FORMATS. BROKE PARTS OUT INTO INDIVIDUAL SHEETS. -105 ADDED MISSING DIM 59° TO INNER CHAMFER, ADDED DETAIL VIEW C. CORRECTED THREAD RELIEF ADDED 45° DIM. -111 ADDED MISSING DIMS .23 AND 2X R.06. -113 ADDED MISSING DIM .479.	12/5/2013	CFS	GE
1A	CH'D TO BELL TOLERANCES.	4/9/2014	DPD	GE



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WORK ORDER
19-6-569 M-5
m-26-17

ASSY QTY	ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-103	1	BALANCE SET ATTACHMENTS			2
	1		-105		ADAPTER	440C COML. GR.	Ø1-3/8 X 2	3
	1		-107		LARGE SPACER	440C COML. GR.	Ø1-1/2 X 3/4	4
	1		-109		STOP	6061	1-1/4 X 1-3/4 X 4-1/4	5
	2		-111		HALF STOP	6061	3/4 X 1-3/4 X 2-1/4	6
	1		-113		SMALL SPACER	440C COML. GR.	Ø3/4 X 3/4	7
	2		-115		SPACER WASHER	440C COML. GR.	Ø7/8 X 1/4	8
			-117	1	SPACER		RED BARN #RB T101544-5	1
			-119	1	MANDREL ASSY.		RED BARN #RB T101576-3	1
			-121	1	STAND ASSY		RED BARN #RB T101576-7	1
			-123	1	BASE		RED BARN #RB T101576-13	1
			-125	1	PLUG (USE ON 206)		RED BARN #RB T101576-29	1
			-127	1	THIN HEX NUT	STEEL CAD PLATED	Ø1-3/4 X 3/8	9
	2	B/O	-129		HEX HEAD CAP SCREW	STEEL, CAD PLATED	NAS6604-35 OR AN4-25A	1
	1	B/O	-131		SOCKET HEAD CAP SCREW	STEEL, BLACK	3/8-24 UNF X 1-3/4 MCMaster-CARR #91251A430	1
	2	B/O	-133		HEX NUT	STEEL, CAD PLATED	NAS509-4 OR AN315-4R	1
	1	B/O	-135		FLAT WASHER	STEEL, CAD PLATED	AN960-616	1
	2	B/O	-137		FLAT WASHER	STEEL, CAD PLATED	AN960-416	1
		B/O	-139	1	BULL'S EYE LEVEL		MCMaster-CARR #2147A11	1
ASSY#	-103							

NOTES:

1. RBT400284 REPLACES BELL 206-210-100-101.
2. RBT400284-103 REPLACES BELL 206-210-100-103.

RED BARN MACHINE

TITLE
TAIL ROTOR BALANCE SET

DWG NO. RBT400284

REV
1A

MAT'L UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

DRAWN BY: PERRITT
APPROVED: D Weil
HEAT TREAT:
FINISH:
SPEC:

1. BREAK ALL SHARP EDGES .015 x 45°
OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER
PLATING

SCALE 1:4 **DATE** 7/29/2010 **SHEET** 1 OF 9

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:			